

Work Order ID 53158

October 23, 2009 10:58:11 AM



Page 1

Item ID: D3983-047
Revision ID: A
Item Name: Closeout Attachment

Accept



Setup Start



Stop



Start Date: 23/10/2009 Start Qty: 10.00

Required Date: 30/10/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

09-10-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3983

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3983-7

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

=7 m-k 09/10/29 (11x)

B 9-10-28

(11)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-28

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Stop



Start Date: 23/10/2009 Start Qty: 10.00

Required Date: 30/10/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
			2) Sorluloz			(ALL)	✓		
130 Small Fab Small Fab	Memo 1- C'sink holes as per dwg 2- Deburr if necessary	0.00 0.00							
						9309/10/02 (11)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			2) Sorluloz			(ALL)	✓		

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Setup Start



Revision ID: A

Stop



Item Name: Closeout Attachment

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

MD 09/11/02

11

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SP 09-11-2

11

Quality Control

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble anchor nuts as per dwg

ES 09/11/04 11

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Accept



Setup Start



Stop



Start Date: 23/10/2009 Start Qty: 10.00
Required Date: 30/10/2009 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) Sorlulos			(+10)	✓		
190 Packaging Packaging	Identify as per dwg & Stock Location: 139.0 Memo	0.00 0.00				9/11/9		10254	
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/11/09			

MF 09-11-09

Picklist Print

October 23, 2009 10:58:15 AM

Page 1

Work Order ID: 53158

Parent Item: D3983-047

Parent Item Name: Closeout Attachment



Comments:

Start Date: 23/10/2009

Required Date: 30/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040  6061-T6 .040 Sheet		Purchased	No			100	sf	90.3986	0.3979 			

B 9-10-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT 113004	90.3986	113004
100742	3.3	
102723	5.93	
105842	12	
106747	5.7516	
107461	11.7841	
109396	22.28	
111224	27.8529	
19380	1.5	

MS21059L3

Purchased

No

170

Each

311.0000

20.0000


Nut Plate

9/16 sf 102

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	311	
109962	11	
111925	300	

20x sf

Picklist Print

Page 2

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Work Order ID: 53158



Parent Item: D3983-047



Parent Item Name: Closeout Attachment

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD343 RIVET		Purchased	No			170	Each	7,861.000	40.0000		9/11/2	(100) SP

10% 102
M7681

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7861

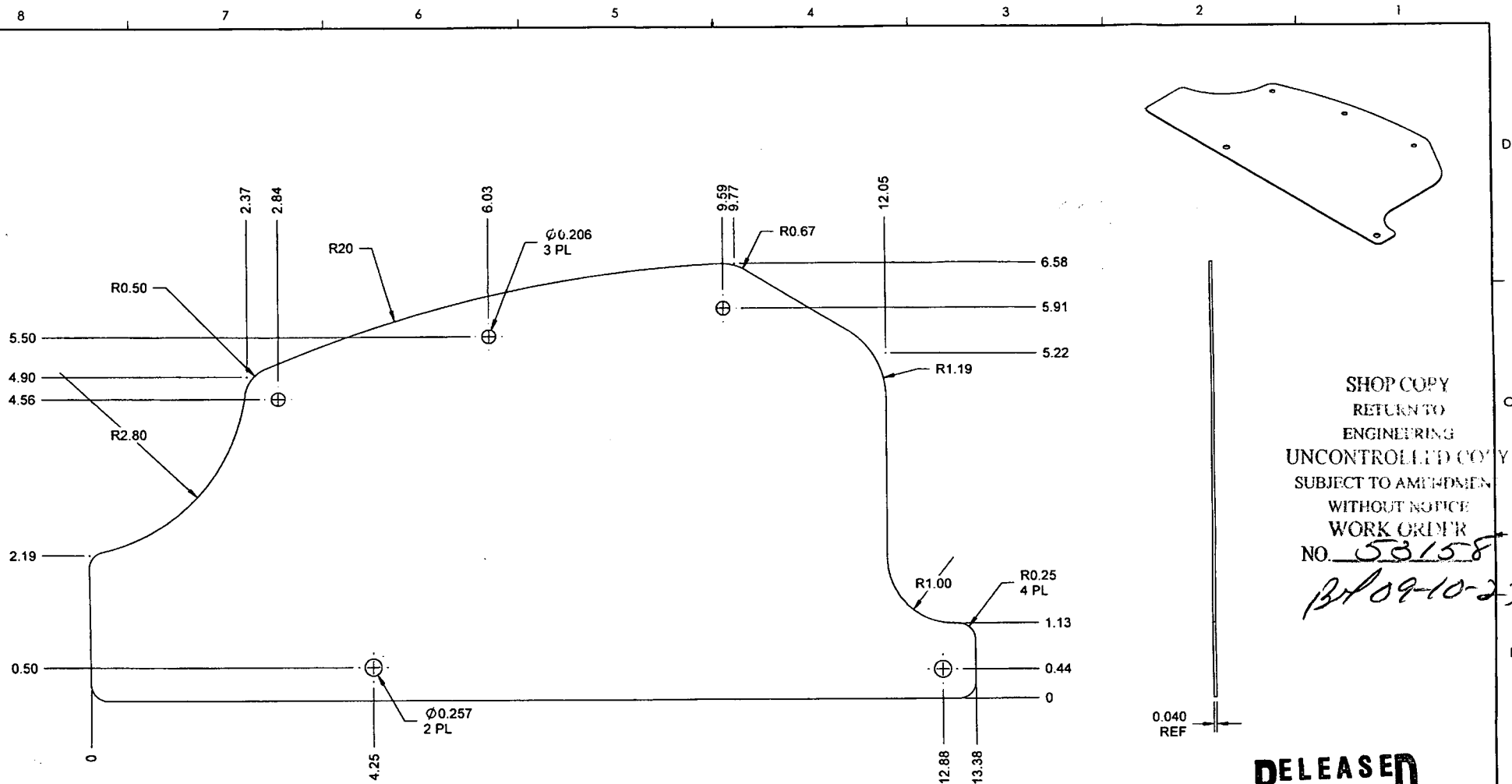
104374

3861

110398

4000

40x SP



D3983-1 OUTER CLOSEOUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53158
B/A 09-10-23

RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-1" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.26 lbs

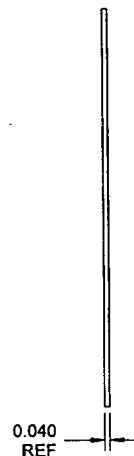
A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3983** REV. A
SHEET 1 OF 7

TITLE **CLOSE OUT KIT** SCALE **NTS**

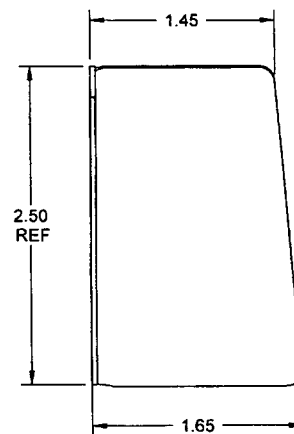
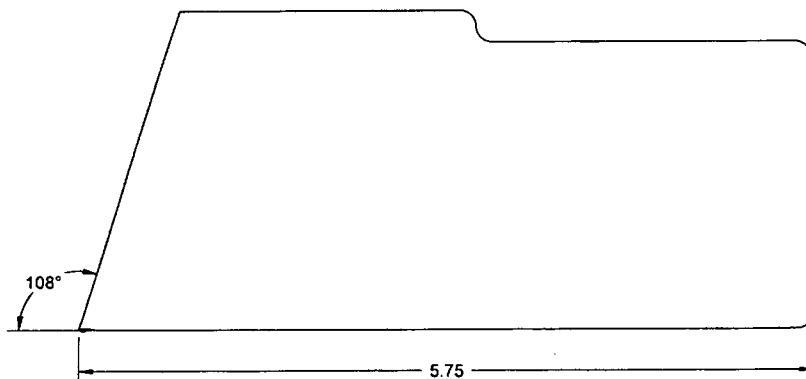
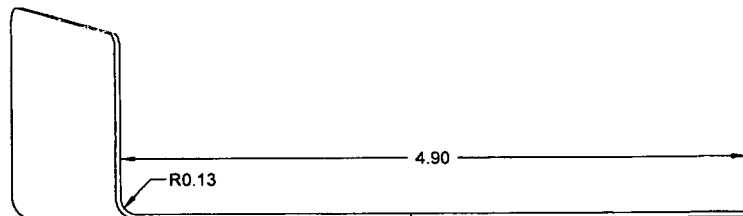
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W/O 53158

RELEASE
2009-10-13

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DRAWN	<i>JS</i>		SHEET 2 OF 2
CHECKED	<i>JS</i>		SCALE
MFG. APPR.	<i>JS</i>		NTS
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	09.09.09		



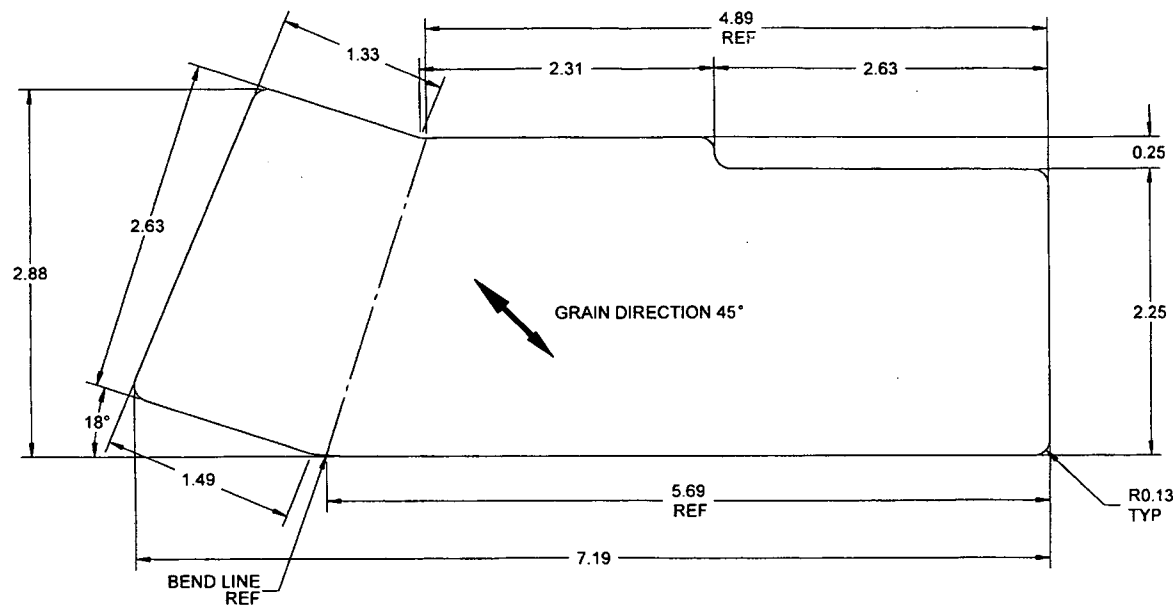
w/o 53158

D3983-5 HINGE CLOSEOUT
(MADE FROM D3983-5F)

RELEASED
2009-10-13

NOTES:
MATERIAL: D3983-5F
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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D3983-5F HINGE CLOSEOUT FLAT PATTERN

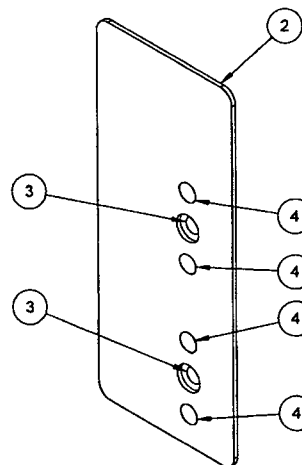
RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040

FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.06 lbs

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MFG. APPR.		D3983	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET



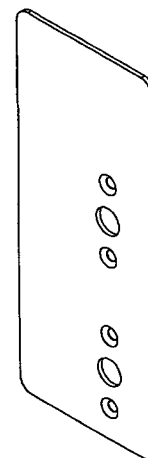
D3983-047 CLOSEOUT ATTACHMENT

W/0 53158

RELEASED
2009-10-13
MD

NOTES:
 MATERIAL: SEE BOM
 FINISH: N/A
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER
 WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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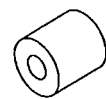


W/O 53158

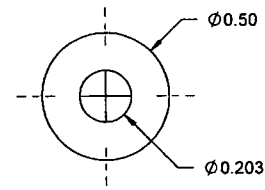
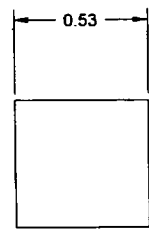
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DRAWN	1		SHEET 6 OF 7
CHECKED	1		SCALE
MFG. APPR.	1		NTS
APPROVED	1		
DE APPR.	1		
DATE	09.09.09		

8 7 6 5 4 3 2 1



W/D 58158



D3983-9 SPACER

RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR, Ø0.500
PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061TR
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.01 lbs

DESIGN	45	DART AEROSPACE LTD	
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MFG. APPR.	45	D3983	SHEET 7 OF 7
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8 7 6 5 4 3 2 1